

Work Order ID 140650

Wednesday, January 13, 2016 7:19:28 AM

140650

Page 1

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Upper Rib Assembly
Start Date: 1/13/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/13/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MCS Date: JAN 13 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4034	C

100 Weld per dwg A/R S.S. rod Batch: B133750 0.00

100

Large Fab Memo 0.04
1- Assemble ribs to hoop and weld as per dwg DT9564
2- Weld bushing in rib and grind weld flush as per dwg

4x CC 1611-18

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00
Quality Control

4x DAS 43 9-89 JAN 18 2016

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00
Quality Control

4x DAS 43 9-89 JAN 18 2016

Work Order ID 140650

Wednesday, January 13, 2016 7:19:28 AM

140650

Page 2

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Upper Rib Assembly
Start Date: 1/13/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/13/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>work</i>	0.00							
130									
Packaging	Memo	0.00				<i>4x</i>	DAS 43 9-89		JAN 18 2016
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01				<i>MCS</i>			JAN 19 2016
Quality Control									

MCS JAN 19 2016

Picklist Print

Wednesday, January 13, 2016 7:19:32 AM

Page 1

Work Order ID: 140650

140650

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 1/13/2016

Required Date: 1/13/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG
REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD
VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 *D4034-1* Rib		Manufactured	No			100	Each	8.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				8					
				139814				4					
				140253				4					
D4034-3 *D4034-3* Rib		Manufactured	No			100	Each	8.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				8					
				139873				1					
				140252				7					
D4021-7 *D4021-7* Hoop		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				1		B139579			
				138986				1					

Picklist Print

Wednesday, January 13, 2016 7:19:32 AM

Work Order ID: 140650

140650

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 1/13/2016

Required Date: 1/13/2016

Start Qty: 4.00

Required Qty: 4.00

D4021-9

Manufactured No

100

Each

89.0000

4

16

D4021-9

Bushing

16-1-18

Location

Loc Qty

Loc Code

WA004

89

120334

2

122601

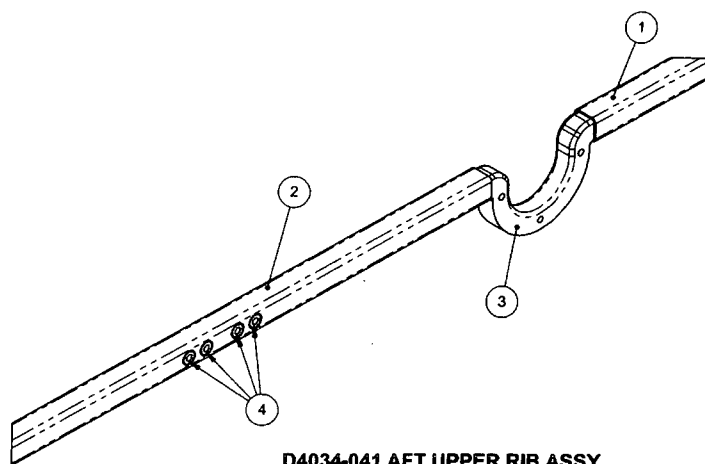
4

138965

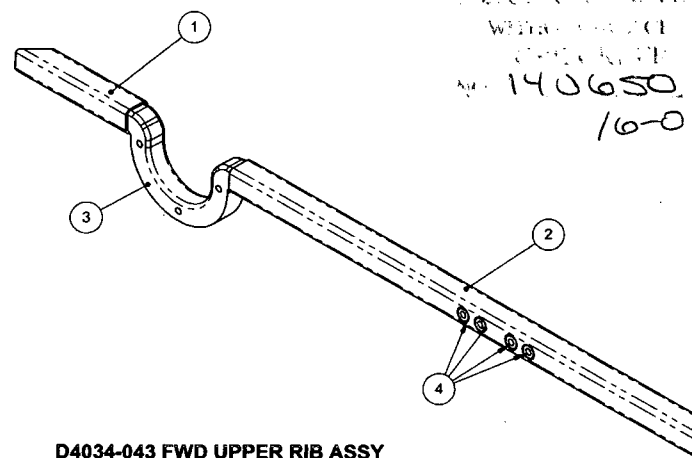
83

16x

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

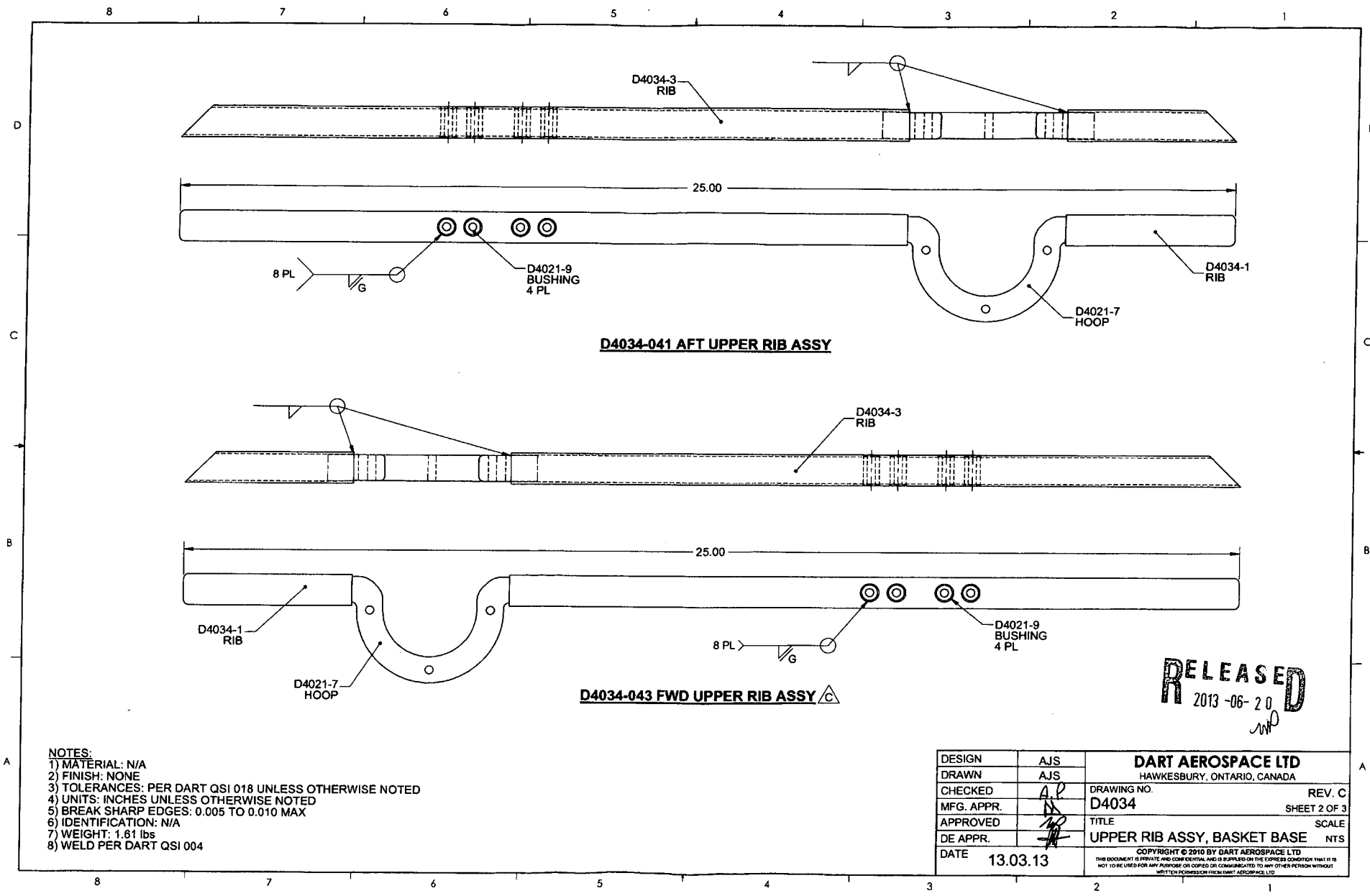


D4034-043 FWD UPPER RIB ASSY

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
REPRODUCTION PROHIBITED
WITHIN THE ACT
OF THE
140650 MJS
10-01-13

RELEASED
2013-06-20

C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	AS	D4034	SHEET 1 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	UPPER RIB ASSY, BASKET BASE	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



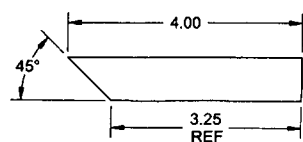
D4034-041 AFT UPPER RIB ASSY

D4034-043 FWD UPPER RIB ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.81 lbs
 - 8) WELD PER DART QSI 004

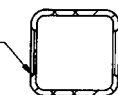
RELEASED
2013-06-20

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	NS	D4034	SHEET 2 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	UPPER RIB ASSY, BASKET BASE	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

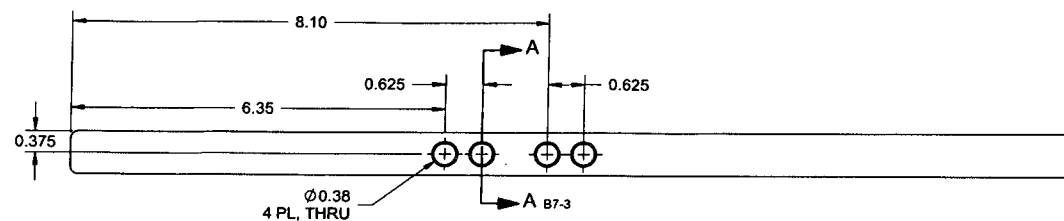
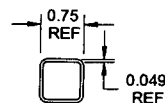


D4034-1 RIB

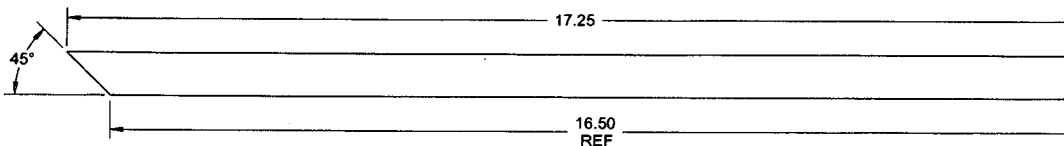
BREAK EDGE
0.030 X 45°
TYP



SECTION A-A C3-3



D4034-3 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

RELEASED
2013-06-28

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	AP	D4034	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	UPPER RIB ASSY, BASKET BASE	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	